



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5569-3

Job Sheet 197150



Part No: D5569-3

Job Qty: 6 pcs

Part Name: Replacement Blade - Basic Aluminum



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5569-3 REV:C IPP REV A 19.06.19 NEW ISSUE JFS VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	6 pcs	7/12/19	7/12/19	1.00	24.00	Mori Seiki TL-40 - 1		DAS 66 2019/08/28 9:89
110	QC 2	6 pcs	7/12/19	7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		DAS 66 2019/08/28 9:89
							QC 2 - 64		



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CANADA
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Container No: S209817



Part: D5569-3

Job No: 197150

Serial No/Batch: S209817

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 08/28/19

7/2/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120 HAAS 5 Axis - B4B	6 pcs	7/12/19	0.75	12.00	HAAS - 5 - B4B	mm 2019/09/06
130 QC 2	6 pcs	7/12/19	0.00	0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	mm 2019/09/06
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140 QC 8	6 pcs	7/12/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B. 19-09-09
					QC 8 - 9	
					QC 8 - 68	

DAS
64
9-89DAS
64
9-89

Plex 7/2/19 9:18 AM Dart.lajeunesse.marie

7/2/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 Hand finish Alod

180 Powdercoat - 1 White Gl(A)-
B4B 11/193439 pcs

7/12/19

0.00 0.21

START: 2:30 a.t. 320° FINISH 3:00

190 QC 3

6
pcs

7/12/19

0.00 0.00

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

BL 19-9-10

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

DAS
40
9-89

SEP 10 2019

200 Packaging 3-1 - Stock - B4B 6
pcs

7/12/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BDAS
28
9-89

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7/2/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	6 pcs	7/12/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89
Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Cut blanks at 22.800" 2-Turn as per dwg. and folio Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - HAAS 5 Axis (HAAS CNC vertical machine #5) 1-Machine as per Folio FC763 and Dwg. D5569-3 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 190 - (QC3- Inspect Part Finish) 200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001 210 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6008-132	Crosstube Extrusion	1.0380 pcs (.173 ea)	100-Mori Seiki TL-40 - 1	F91908		
				5192997?		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Mori Seiki TL-40 - 1	D6008-132	1	61	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order:	157150
Description: SKIDTUBE BLADE		Part Number:	D5569-3 TRN
Inspection Dwg: D5569	Rev: C	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.937	+0.010/-0.000	2.943	✓		CNC-08	
3.240	+0.010/-0.000	3.246	✓		CNC-08	
20.100	+/-0.030	20.10	✓		Tape	
CNC (D5569-3)						
2.937	+/-0.010	2.944	✓		Vernier	
0.516	+0.005/-0.001	0.518	✓		Pin gauge	
3.240	+/-0.010	3.247	✓		high gauge	
0.551	+/-0.010	0.550	✓		Vernier	
11.00	+/-0.030	11.00 OK	✓		Exhaust	
11.250	+/-0.030	11.250 OK	✓		Exhaust	
17.50	+/-0.030	17.502	✓		Tape	
1.48	+/-0.020	1.472	✓		high gauge	
2.598	+/-0.010	2.605	✓		high gauge	
3.54	+/-0.030	3.542	✓		high gauge	
1.50	+/-0.030	1.530	✓		high gauge	
13.00	+/-0.030	13.030	✓		high gauge	
15.00	+/-0.030	15.030	✓		high gauge	
0.257	+0.005/-0.001	0.256	✓		Pin gauge	
2.43	+/-0.020	2.408	✓			

Measured by: LLM	Checked by: B.	QC Inspector:
Date: 2019/09/06	Date: 19-09-09	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

1.404